

Work Order ID 60243

Tuesday, June 29, 2010 2:42:17 PM

Page 1

Item ID: D3912-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Eyebolt Receiver Assembly

Start Date: 6/29/2010 Start Qty: 1.00

Required Date: 7/2/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *10-6-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

PRELIMINARY

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3912	<i>prelim</i>

100	Pick Kit	0.00
-----	----------	------

Packaging	Memo	0.00
-----------	------	------

Packaging		
-----------	--	--



110		0.00
-----	--	------

Small Fab	Memo	0.00
-----------	------	------

Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG	
-----------	---	--

2- Install helical, spring plunger and spring pin lanyard assy as per dwg
***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L)
IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE
TO ENLARGE WASHER HOLE FOR IT TO FIT***

*EB 10/06/30**EB 10/06/30**(PTC)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-06-30	110	See attached parts list (hand written) for correct Assy per dwg. Needle washer update to 616.	EP	10/06/30	①	 10.04.23 61642	 10.06.30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60243

Tuesday, June 29, 2010 2:42:17 PM

Page 2

Item ID: D3912-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Eyebolt Receiver Assembly

Start Date: 6/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 1.00


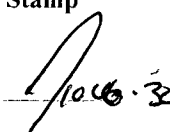


Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



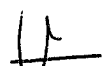

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

See P70



A. Rev. B 10.07.23.
Test only.

POSITIVE RECALL
EFFECTIVE 
RELEASED  AUTH 
DATE 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 2:42:16 PM

Page 1

Work Order ID: 60243

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Start Date: 6/29/2010

Required Date: 7/2/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C516L  WASHER	NAS1149C0532 R	Purchased	No			100	Each	14.0000	1	1			
<div> <div>***ONLY IF NECESSARY, SEE MEMO IN SEQ 110***</div> <div> <div>N/A PA1</div> <div>ST347</div> <div>111916</div> </div> </div>													
MS21209C6-10  Heli Coil, screw locking, red		Purchased	No			100	Each	46.0000	1	1			
<div> <div>N/A PA1</div> <div> <div>ST304</div> <div>108847</div> <div>113705</div> <div>ST305</div> <div>114310</div> </div> </div>													
D3912-3  Eyebolt Block		Manufactured	No			100	Each	12.0000	2	2			
<div> <div>ST096</div> <div>59430</div> </div>													

EB 6/30/30
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 2:42:17 PM

Page 2

Work Order ID: 60243



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 6/29/2010

Required Date: 7/2/2010

Start Qty: 1.00

Required Qty: 1.00

D3912-5

 Eyebolt Plate

Manufactured No

100 Each 3.0000 2



2
6/30/06/30

Location

Loc Qty

Loc Code

ST096

3

58782

3

D3912-1

 Eyebolt

Manufactured No

100 Each 6.0000 1



B 60171

2
SB 12/06/29

Location

Loc Qty

Loc Code

FG096

6

59441

6

MS20615-4M20

 RIVET

Purchased No

100 Each 330.0000 8



8
6/30/06/30

Location

Loc Qty

Loc Code

ST323

330

114808

160

115054

170

D3810-1

 Hand Retractable Spring Plunger

Manufactured No

100 Each 18.0000 1



8
1

Location

Loc Qty

Loc Code

ST090

18

54523

1

57319

17

D4028-041

 Spring Pin Lanyard Assembly

Manufactured No

100 Each 0.0000 1



E
1

NIA
PA1

NIA
PA1

Tuesday, June 29, 2010 2:42:17 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

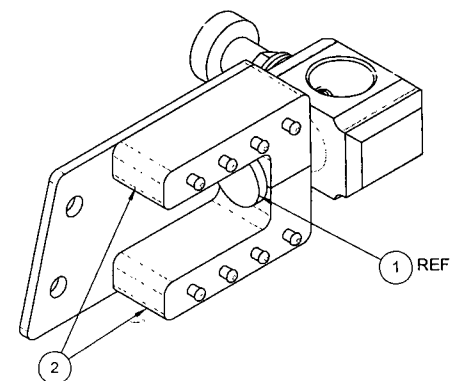
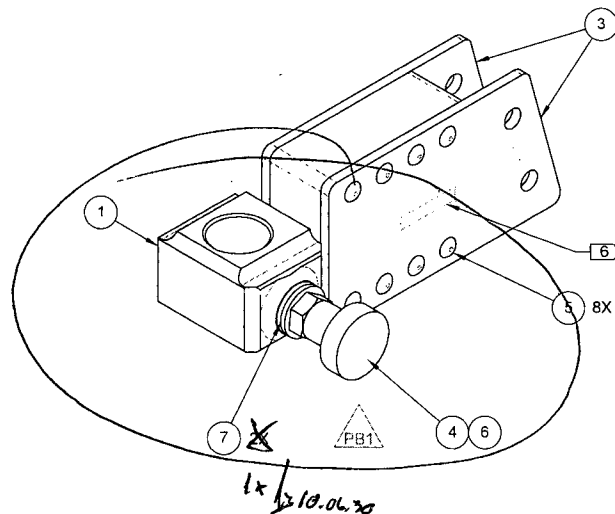
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0663P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.61 lbs

PRELIMINARY ISSUE

1 10.04.21

PB1	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (2X) WASHER NAS1149F0663P ADDED; BOSS ADDED TO D3912-1.	JPH	10.04.21
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	97	DRAWING NO.	REV. PB1
MFG. APPR.		D3912	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE	10.04.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

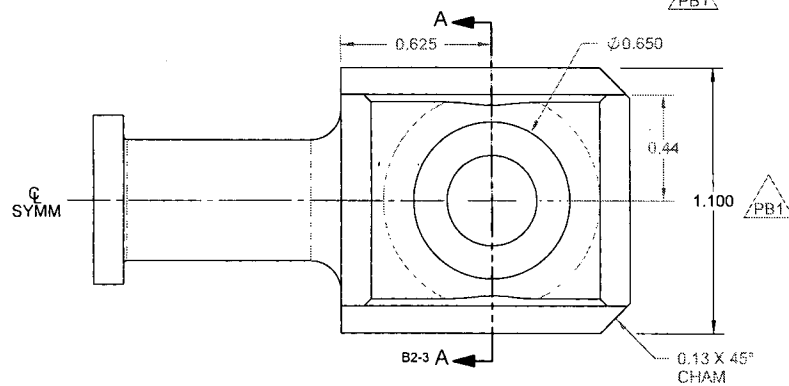
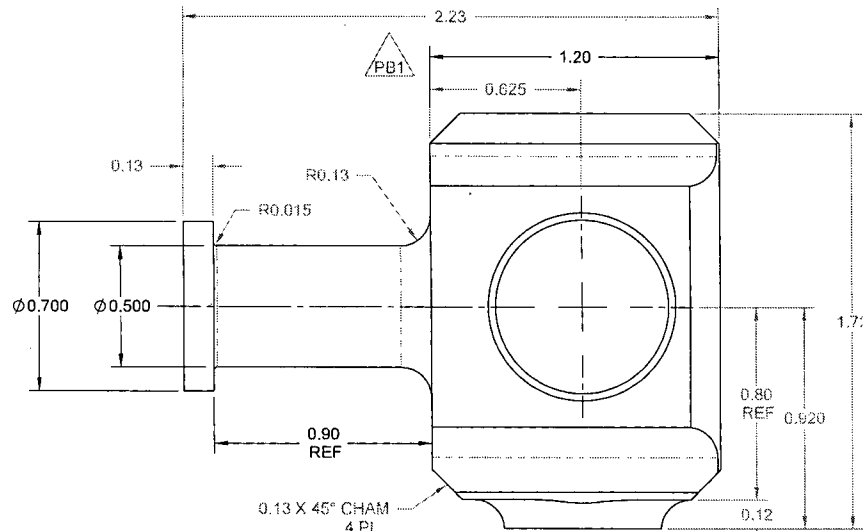
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.48 lbs

DRILL & TAP
3/8-24 FOR
MS21209-F015
HELICAL INSERT

Ø 2.00
STOCK
REF

R0.13
TYP

0.030 X 45°
CHAM

0.030 X 45°
CHAM

SECTION A-A B6-3

PRELIMINARY ISSUE

1 10.04.21

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

AJS
JPH
97

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3912

TITLE
EYEBOLT RECEIVER ASSY

REV. PB1

SHEET 2 OF 3

SCALE

NTS

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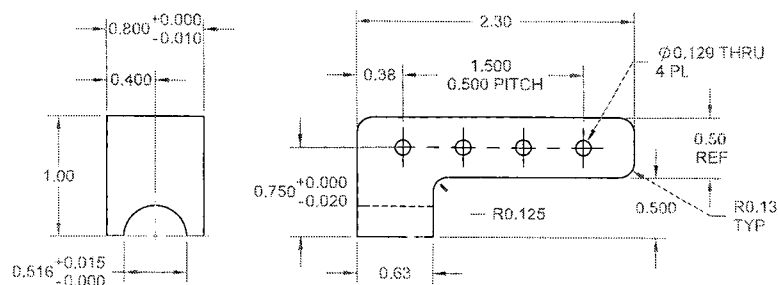
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

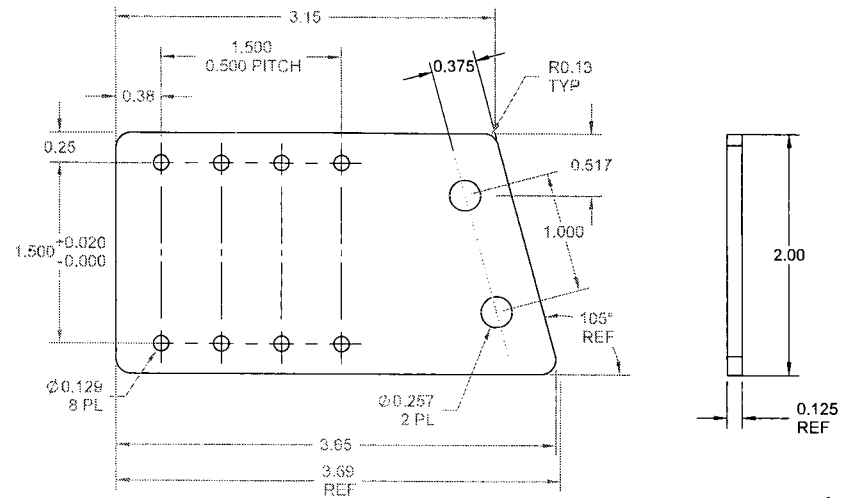
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

PRELIMINARY ISSUE

1 10.04.21

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. PB1
MFG. APPR.		D3912	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	
DATE	10.04.21	NTS	
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#60243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- Washer : Bath #

AV960C616

M19185

QTY: 2 | ~~1~~

-Helic - Coil

MS21209-FL 15

M108170

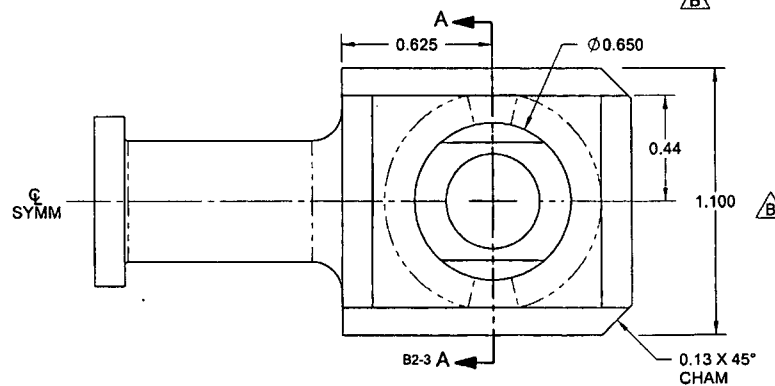
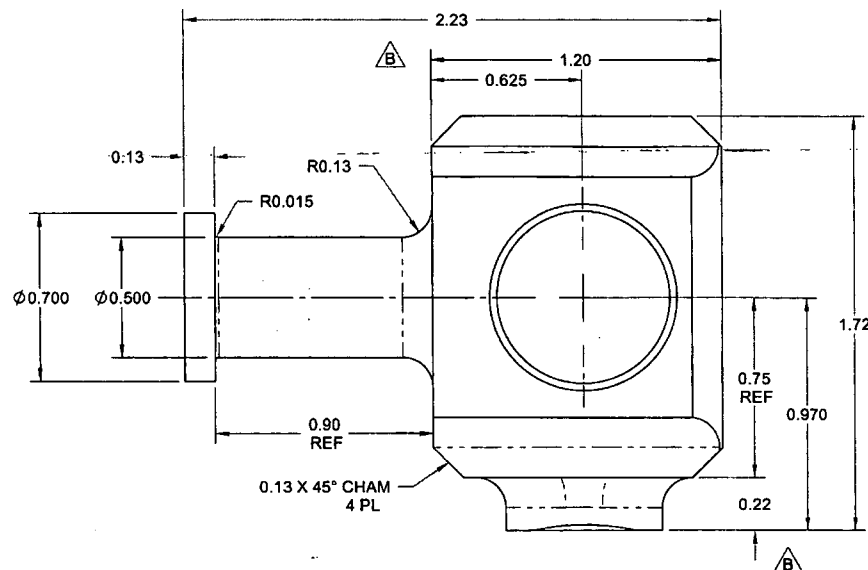
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-Spring Plunger

D3801-1

B40736

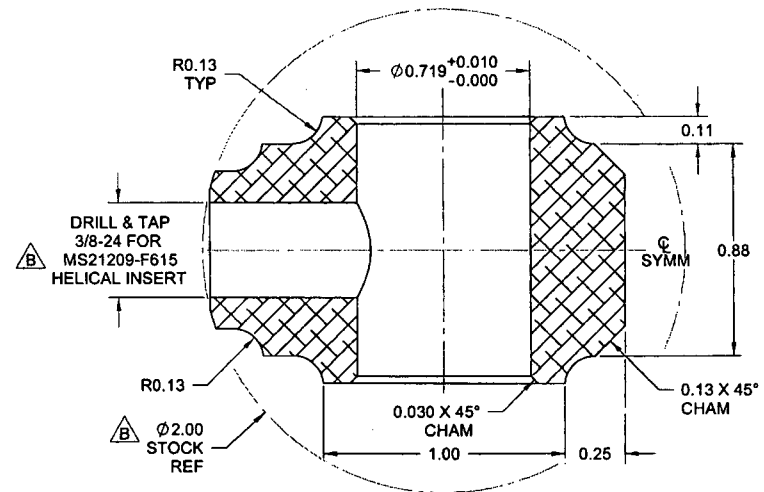
QTY: 1 ~~2~~



D3912-1 EYEBOLT

NOTES:

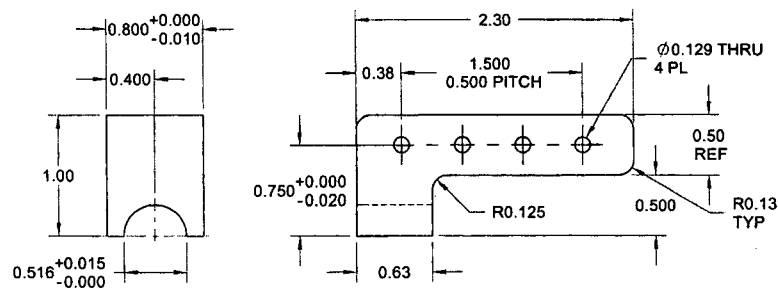
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



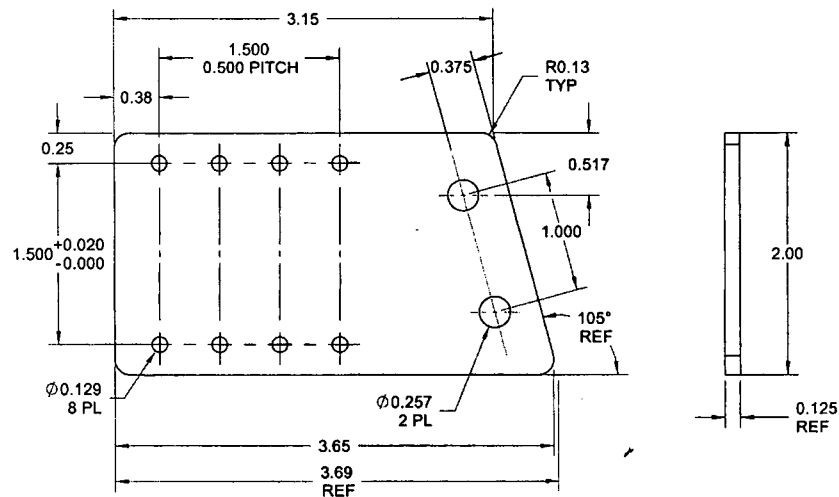
SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	1.5	DART AEROSPACE LTD	
DRAWN	1.5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1.5	DRAWING NO.	REV. B
MFG. APPR.	1.5	D3912	SHEET 2 OF 3
APPROVED	1.5	TITLE	SCALE
DE APPR.	1.5	EYEBOLT RECEIVER ASSY	NTS
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
sm

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	81	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	9/1	D3912	SHEET 3 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	EYEBOLT RECEIVER ASSY	NTS
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